







Date: Tuesday, 27/01/2009 11:09:31 AM
 User: Julie Dawson

Process Sheet

| | |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : MOUNTING ANGLE |
| Job Number : 45243 | |
| Estimate Number : 10509 | |
| P.O. Number : | Part Number : D2564 |
| This Issue : 27/01/2009 S.O. No. : | Drawing Number : D2564 REV. B1 |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : 27/01/2009 Type : MACHINED PARTS | Drawing Revision : B1 |
| Previous Run : 40936 | Material : |
| Written By : | Due Date : 12/02/2009 Qty: 40 Um: Each |
| Checked & Approved By : <u>JKD 09.01.27</u> | |
| Comment : Est:D 02.09.09 Re-format; Added FA276 Folio KJ/RF | |
| Additional Product | |
| Job Number:  | |
| Seq. #: | Machine Or Operation: Description : |
| 1.0 | D6207 Angle Extrusion |
|  | |
| Comment: Qty.: 0.0962 f(s)/Unit Total: 3.8472 f(s) Angle Extrusion Material: D6207 (1" x 1" x .125 angle) 6061-T6/T6511 (QQ-A-200/8) (D6207) Batch: <u>B41418</u> <u>mk 09/01/28</u> (40) | |
| 2.0 | BAND SAW BAND SAW |
|  | |
| Comment: BAND SAW Cut D6207 Extrusion: 1.00" Long (+0.000/-0.030) <u>mk 09/01/28</u> (40) | |
| 3.0 | HAAS1 HAAS CNC VERTICAL MACHINING #1 |
|  | |
| Comment: HAAS CNC VERTICAL MACHINING #1 1- Mill as per Folio FA276 Rev: <u>B</u> & Dwg D2564 Rev: <u>B</u> (40) 2-Deburr if necessary <u>H.A 09/01/28</u> | |
| 4.0 | QC2 INSPECT PARTS AS THEY COME OFF MACHINE |
|  | |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>H.A 09/01/28</u> (40) | |
| 5.0 | QC8 SECOND CHECK |
|  | |
| Comment: SECOND CHECK <u>JK 09/01/30</u> | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 27/01/2009 11:09:32 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING ANGLE

Job Number: 45243

Part Number: D2564

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



(40x)

Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: *PAT*

9/12/12

SEP

7.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/02

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-02-02

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

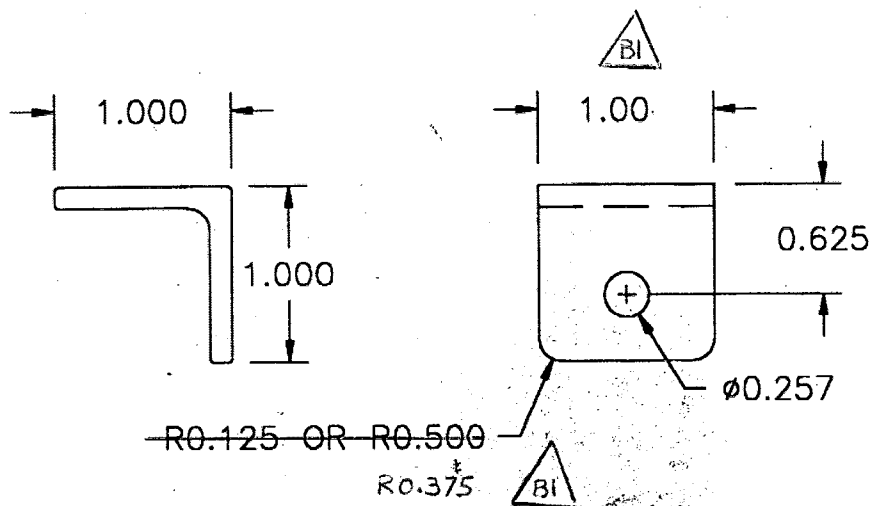
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART

| | | | | | |
|------------------|----------|-------------------------|--|--|--------------|
| DESIGN | | DRAWN BY | | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| MIKE M | | MIKE M | | DRAWING NO. D2564 | REV. B |
| CHECKED BW | | APPROVED BW | | | SHEET 1 OF 1 |
| DATE 96:04:30 | | TITLE MOUNTING ANGLE | | | SCALE 1: |
| B | 97:05:06 | | MODIFIED DIMENSIONS | | |
| BI | 02.09.17 | | R0.375 WAS R0.125 OR R0.500; 1.00 WAS 1.000 | | |

RELEASED
97/05/06 BWNOTES:

- 1) MATERIAL: 6061-T6 ANGLE 1.0 X 1.0 X 0.125
MAKE FROM D6207-XXX ANGLE EXTRUSION
- 2) BREAK ALL SHARP EDGES 0.005 - 0.015
- 3) TOLERANCES PER DART QSI Q18 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. WS243

